

5/44

|  |  |                     |           |
|--|--|---------------------|-----------|
| <b>DART AEROSPACE LTD</b>                  |  | <b>Work Order:</b>  | 24408     |
| <b>Description:</b> Hi - Step Leg Assembly |  | <b>Part Number:</b> | D3065-041 |
| <b>Dwg:</b> D3065 Rev. <del>A1</del> A2    |  | <b>Qty:</b>         | 60        |
| RF 03.02.17 RF 03.02.28                    |  | Page 1 of 2         |           |

| Step | Location | Procedure  | By  | Date     | Qty |
|------|----------|--|-----|----------|-----|
| 1    | DC       | Issue Traveller <i>Dwg. not required RF 02.11.04</i><br>(Minimum lots of 30)   | JG  | 05.10.03 | 60  |
| 2    | MV       | Cut blanks: 3.600" x 4.500" (grain along 4.500") <i>please make</i><br>Material: 2024-T3 Sheet (QQ-A-250/4) 0.040" thick <i>75 of</i><br>(M2024T3S.040) Batch <u>M17948</u>                                | JG  | 05/10/31 | 75  |
| 3    | MV       | Cut blanks: 6.600" x <del>4.250"</del> (grain along <del>4.250"</del> <i>4.320"</i> ) <i>RF</i><br>Material: 2024-T3 Sheet (QQ-A-250/4) 0.040" thick <i>02.11.29</i><br>(M2024T3S.040) Batch <u>M17948</u> | JG  | 05/10/31 | 60  |
| 4    | MV       | Cut blanks: 4.580" x 4.500" (grain along 4.500")<br>Material: 2024-T3 Sheet (QQ-A-250/4) 0.040" thick<br>(M2024T3S.040) Batch <u>M17948</u>  | JG  | 05/10/31 | 60  |
| 5    | MV       | Cut blanks: 16.61" x 8.51" (grain along 8.51") for each leg.<br>Material: 5052-H32 Sheet (QQ-A-250/8) 0.080" thick<br>(M5052H32S.080) Batch <u>M18710</u><br>Identify as D3065-5 <i>M19052</i>             | JG  | 05/11/01 | 120 |
| 6    | MV       | Cut blanks: 16.490" x 0.750" for each spacer. (-0.00/+0.010)<br>Material: 5052-H32 Sheet (QQ-A-250/8) 0.080" thick<br>(M5052H32S.080) Batch <u>M19052</u>  | JG  | 05/11/03 | 120 |
| 7    | MV       | Machine D3065-1 as per folio FA182 and Dwg D3065, use<br>stack of 15.  | J.L | 05.11.04 | 60  |
| 8    | MV       | Deburr to take measurement   | J.L | 05.11.04 | 60  |
| 9    | QC2      | Inspect parts as they come off the CNC machine   | J.L | 05.11.04 | 60  |
| 10   | QC8      | Second check   | J.L | 05.11.04 | 60  |
| 11   | MV       | Machine D3065-3 as per folio FA180 and Dwg D3065, use<br>stack of 15.  | J.L | 05.11.04 | 60  |
| 12   | MV       | Deburr to take measurement   | J.L | 05.11.04 | 60  |
| 13   | QC2      | Inspect parts as they come off the CNC machine   | J.L | 05.11.04 | 60  |
| 14   | QC8      | Second check   | J.L | 05.11.04 | 60  |
| 15   | MV       | Machine D3065-7 as per folio FA181 and Dwg D3065, use<br>stack of 15.  | J.L | 05.11.04 | 60  |
| 16   | MV       | Deburr to take measurement   | J.L | 05.11.04 | 60  |
| 17   | QC2      | Inspect parts as they come off the CNC machine   | J.L | 05.11.04 | 60  |
| 18   | QC8      | Second check   | J.L | 05.11.04 | 60  |
| 19   | MV       | Machine D3065-5 as per folio FA179 and Dwg D3065, use<br>stack of 10.  | En  | 05/11/04 | 60  |

RELEASED  
02/11/04 RF

PTO

05.03.09  
#24

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                 |                          |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Mfg / Design<br>Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                 |                          |
|      |      |                    |    |      |     |                                 |                          |

| NCR:     |      | WORK ORDER NON-CONFORMANCE (NCR)                                  |                             |                                  |                 |                           |                        |                          |
|----------|------|---|-----------------------------|----------------------------------|-----------------|---------------------------|------------------------|--------------------------|
| DATE     | STEP | Description of NC<br>Section A                                    | Corrective Action Section B |                                  |                 | Verification<br>Section C | Approval<br>Design Mgr | Approval<br>QC Inspector |
|          |      |   | Initial<br>Design Mgr       | Action Description<br>Design Mgr | Sign &<br>Date  |                           |                        |                          |
| 05/11/04 | 7    | - 1 stack of 15 scrap<br>stacked moved while<br>machining P3065-1 |                             | destroy                          | J.L<br>05/11/04 |                           |                        |                          |
|          |      |   |                             |                                  |                 |                           |                        |                          |
|          |      |   |                             |                                  |                 |                           |                        |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date &amp; initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_


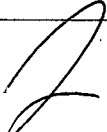
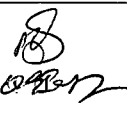
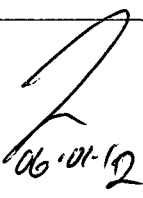
|  |  |                     |             |
|--|--|---------------------|-------------|
| <b>DART AEROSPACE LTD</b>                  |  | <b>Work Order:</b>  | 24408       |
| <b>Description:</b> Hi - Step Leg Assembly |  | <b>Part Number:</b> | D3065-041   |
| RF 03.02.28                                |  |                     |             |
| <b>Dwg:</b> D3065 Rev. A1 A2               |  | <b>Qty:</b>         | 60          |
| RF 03.02.17                                |  |                     | Page 2 of 2 |

| Step | Location     | Procedure   | By      | Date        | Qty         |       |   |         |        |         |   |         |        |         |   |         |     |         |   |         |        |         |    |              |       |         |    |          |    |
|------|--------------|---|---------|-------------|-------------|-------|---|---------|--------|---------|---|---------|--------|---------|---|---------|-----|---------|---|---------|--------|---------|----|--------------|-------|---------|----|----------|----|
| 19   | MV           | Machine D3065-5 as per folio FA179 and Dwg D3065, use stack of 10.  | SD      | 05.11.06    | 100 -20     |       |   |         |        |         |   |         |        |         |   |         |     |         |   |         |        |         |    |              |       |         |    |          |    |
| 20   | MV           | Deburr to take measurement  | SD      | 05.11.06    | 100 -20     |       |   |         |        |         |   |         |        |         |   |         |     |         |   |         |        |         |    |              |       |         |    |          |    |
| 21   | QC2          | Inspect parts as they come off the CNC machine  | SD      | 05.11.06    | 100 -20     |       |   |         |        |         |   |         |        |         |   |         |     |         |   |         |        |         |    |              |       |         |    |          |    |
| 22   | QC8          | Second check  | SD      | 05.11.06    | 100 -20     |       |   |         |        |         |   |         |        |         |   |         |     |         |   |         |        |         |    |              |       |         |    |          |    |
| 23   | MV           | Machine D3066-1 as per Folio FA280 and Dwg D3066, use stack of 10.  | J.L     | 05.12.02    | 120         |       |   |         |        |         |   |         |        |         |   |         |     |         |   |         |        |         |    |              |       |         |    |          |    |
| 24   | MV           | Deburr to take measurement  | J.L     | 05.12.02    | 120         |       |   |         |        |         |   |         |        |         |   |         |     |         |   |         |        |         |    |              |       |         |    |          |    |
| 25   | QC2          | Inspect parts as they come off the CNC machine  | J.L     | 05.12.02    | 120         |       |   |         |        |         |   |         |        |         |   |         |     |         |   |         |        |         |    |              |       |         |    |          |    |
| 26   | QC8          | Second check  | J.L     | 05.12.02    | 120         |       |   |         |        |         |   |         |        |         |   |         |     |         |   |         |        |         |    |              |       |         |    |          |    |
| 27   | GA           | Deburr D3065-1, D3065-3, D3065-5, D3065-7 & D3066-1 stack.  | SD      | 05/12/04    | 60          |       |   |         |        |         |   |         |        |         |   |         |     |         |   |         |        |         |    |              |       |         |    |          |    |
| 28   | GB           | Bend D3065-1, D3065-3 & D3065-7 as per Dwg D3065  | DL      | 05/12/09    | 60          |       |   |         |        |         |   |         |        |         |   |         |     |         |   |         |        |         |    |              |       |         |    |          |    |
| 29   | QC5          | Inspect work to Step 28   | DL      | 05/12/08    | 60          |       |   |         |        |         |   |         |        |         |   |         |     |         |   |         |        |         |    |              |       |         |    |          |    |
| 30   | FP           | Chemical conversion coat as per QSI 005 4.1 RF 02.11.06 D3065-1, D3065-3, D3065-5, D3065-7 & D3066-1  | DL      | 05/12/13    | 60          |       |   |         |        |         |   |         |        |         |   |         |     |         |   |         |        |         |    |              |       |         |    |          |    |
| 31   | GA           | Assemble as per Dwg D3065 and identify as D3065-041 Assembly.<br><table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>1</td><td>D3065-1</td><td>Spacer</td><td>B 24408</td></tr><tr><td>1</td><td>D3065-3</td><td>Spacer</td><td>B 24408</td></tr><tr><td>2</td><td>D3065-5</td><td>Leg</td><td>A 24408</td></tr><tr><td>1</td><td>D3065-7</td><td>Spacer</td><td>B 24408</td></tr><tr><td>30</td><td>MS20470AD4-4</td><td>Rivet</td><td>M 17944</td></tr></table> | Qty     | Part Number | Description | Batch | 1 | D3065-1 | Spacer | B 24408 | 1 | D3065-3 | Spacer | B 24408 | 2 | D3065-5 | Leg | A 24408 | 1 | D3065-7 | Spacer | B 24408 | 30 | MS20470AD4-4 | Rivet | M 17944 | DL | 06/01/10 | 60 |
| Qty  | Part Number  | Description   | Batch   |             |             |       |   |         |        |         |   |         |        |         |   |         |     |         |   |         |        |         |    |              |       |         |    |          |    |
| 1    | D3065-1      | Spacer  | B 24408 |             |             |       |   |         |        |         |   |         |        |         |   |         |     |         |   |         |        |         |    |              |       |         |    |          |    |
| 1    | D3065-3      | Spacer  | B 24408 |             |             |       |   |         |        |         |   |         |        |         |   |         |     |         |   |         |        |         |    |              |       |         |    |          |    |
| 2    | D3065-5      | Leg   | A 24408 |             |             |       |   |         |        |         |   |         |        |         |   |         |     |         |   |         |        |         |    |              |       |         |    |          |    |
| 1    | D3065-7      | Spacer  | B 24408 |             |             |       |   |         |        |         |   |         |        |         |   |         |     |         |   |         |        |         |    |              |       |         |    |          |    |
| 30   | MS20470AD4-4 | Rivet   | M 17944 |             |             |       |   |         |        |         |   |         |        |         |   |         |     |         |   |         |        |         |    |              |       |         |    |          |    |
| 32   | QC5          | Inspect work to Step 31   | DL      | 06.01.12    | 60          |       |   |         |        |         |   |         |        |         |   |         |     |         |   |         |        |         |    |              |       |         |    |          |    |
| 33   | GA           | Identify and Stock<br>D3065-041 Hi-Step Leg Assembly<br>D3066-1 Spacer 238/339  | DL      | 06/01/13    | 60          |       |   |         |        |         |   |         |        |         |   |         |     |         |   |         |        |         |    |              |       |         |    |          |    |
| 34   | AC           | Cost / part   | DL      | 06.01.16    | 60          |       |   |         |        |         |   |         |        |         |   |         |     |         |   |         |        |         |    |              |       |         |    |          |    |
| 35   | DC           | Close W/O<br>Inspect Level 21   | DL      |             |             |       |   |         |        |         |   |         |        |         |   |         |     |         |   |         |        |         |    |              |       |         |    |          |    |

| Rev | Date     | Change                                   | Revised By | Approved |
|-----|----------|--|------------|----------|
| A   | 01.12.10 | New Issue                                | SM         |          |
| B   | 02.09.10 | Re-format; Incorporated D3065-1/-3/-5/-7 | KJ         |          |
| C   | 02.11.01 | Incorporated D3066-1 IPP                 | KJ RF      |          |

**RELEASED**  
02/11/04 RF

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                 |                          |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Mfg / Design<br>Mgr | Approval<br>QC Inspector |
|      | 27   |                    |    |      |     |                                 |                          |
|      |      |                    |    |      |     |                                 |                          |

| NCR:     |      | WORK ORDER NON-CONFORMANCE (NCR)  |   |   |                |   |   |   |
|----------|------|---|---|---|----------------|---|---|---|
| DATE     | STEP | Description of NC<br>Section A  | Corrective Action Section B   |   |                | Verification<br>Section C   | Approval<br>Design Mgr  | Approval<br>QC Inspector  |
|          |      |   | Initial<br>Design Mgr   | Action Description<br>Design Mgr  | Sign &<br>Date |   |   |   |
| 06-01-11 | 31   | Hole oversized when removing a rivet in D3065-1, ALSO 1x D3065-5 HAS A deep grind mark on a rivet hole after removing A scratch in the mat'l. |  | Scrap: replace D3065-1 (B 23349) and assemble as per Dwg. Scrap and replace D3065-5 (B23618) and rivets. (M17444 Qty 15) Assemble as per Dwg. | SB<br>06/01/12 | <br>06-01-12 |  | <br>06-01-12 |
|          |      |   |   |   |                |   |   |   |
|          |      |   |   |   |                |   |   |   |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date &amp; initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_













# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Oct 03, 2005  
11:23 am

Work Order No : 0024408  
Project Name : D3065-041  
Project For : WK544  
Work Order Type : Main  
Main WO Number :  
House Part Number : D3065-041  
Description : Step Leg Assembly  
Manufactured : Yes  
Amount Req'd : 60  
Amount Done : 0  
Start Date : 10-03-05  
Est Finish Date : 11-05-05  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00

Order Entry No :  
OE Value : 0.00

Est Mark Up : 0.000%  
Actual Mark Up : 0.000%

\$0 Posted to Finished Goods

|                   | Estimated | Actual | Var. % | Posted | To Post |
|-------------------|-----------|--------|--------|--------|---------|
| Material Cost     | 0.00      | 0.00   | 0.00   | 0.00   | 0.00    |
| Engineering Hours | 0.00      | 0.00   | 0.00   |        |         |
| Engineering Cost  | 0.00      | 0.00   | 0.00   | 0.00   | 0.00    |
| Production Hours  | 0.00      | 0.00   | 0.00   |        |         |
| Production Cost   | 0.00      | 0.00   | 0.00   | 0.00   | 0.00    |
| Packaging Hours   | 0.00      | 0.00   | 0.00   |        |         |
| Packaging Cost    | 0.00      | 0.00   | 0.00   | 0.00   | 0.00    |
| OverHead Hours    | 0.00      | 0.00   | 0.00   |        |         |
| OverHead Cost     | 0.00      | 0.00   | 0.00   | 0.00   | 0.00    |
| CNC Hours         | 0.00      | 0.00   | 0.00   |        |         |
| CNC               | 0.00      | 0.00   | 0.00   | 0.00   | 0.00    |
| Misc. Hours       | 0.00      | 0.00   | 0.00   |        |         |
| Misc.             | 0.00      | 0.00   | 0.00   | 0.00   | 0.00    |
| Burden            | 0.00      | 0.00   | 0.00   |        |         |
| Total Cost        | 0.00      | 0.00   | 0.00   |        |         |
| Mark up           | 0.000     | 0.000  |        |        |         |
| Selling Cost      | 0.00      | 0.00   |        |        |         |

|                        | Estimated | Actual |
|------------------------|-----------|--------|
| Labour Hrs/Amount Done | 0.00      | 0.00   |
| Profits/(Loss)         | 0.00      | 0.00   |